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WAR FOOD ADMINISTRATION  
Office of Marketing Services  
Washington 25, D. C.

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BUTTER GRADERS' MEMORANDUM NO. 6

To: Butter Supervisors and Graders

From: B. J. Ommodt, Senior Marketing Specialist, Inspection and Grading Division, Dairy and Poultry Branch *B. J. Ommodt*

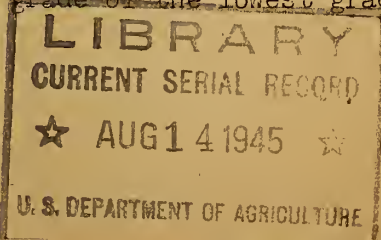
Subject: Procedure to be Followed in Grading, Weighing and Preparation of Graders' Memorandums and Certificates Covering Butter Offered for Sale to the DPMA

The instructions contained herein supersede all previous instructions and shall be fully adhered to in order to maintain uniformity in procedure.

MANIFEST COVERING LIST OF CHURNINGS - The grader shall obtain from the vendor a complete manifest showing churn numbers and the number of packages for each churning in the lot. Check list closely for duplications of churn numbers or other discrepancies. When the lot offered for grading is in print form, the original churning numbers from the bulk packages should be carried forward on the packages containing the print butter.

SELECTING SAMPLES AND GRADING -

(a) The grader should select one sample from each churning in the lot for grading and weighing. In the event it is not possible for the grader to select samples and it is necessary to grade samples set out by the vendor, a spot check should be made of at least 10% of the churnings, or not less than five churnings per carlot. When the butter is stored in a public warehouse, an employee of the warehouse may be designated to select the samples. The samples should be in proper condition for grading and should be at least 48 hours old at time of grading. In case of print butter, the samples should be broken open for thorough examination of the interior. Also examine surface of print samples for condition and off flavors. In the event butter is not printed by churnings, or the grader has reason to believe that the churning numbers on the print packages are not representative of the butter in the lot, the grader should select at random 10% of the packages in the lot for grading. If there is any variation in grade of the 10% samples selected the entire lot takes the grade of the lowest grade sample.



(b) Print wrappers must show name and address of manufacturer or distributor, net weight, and name of product, to comply with the Food, Drug and Cosmetic Act. One-quarter pound prints or rolls are not purchased by the DPMA.

QUALITY - DPMA Announcement 9 provides that:

(a) All butter delivered under this announcement to the DPMA shall be salt butter and meet the requirements for the grade or grades offered, which shall be U. S. grades and not less than Grade B or 90 score. Amendment 3 to Announcement No. 9 provides for acceptance of mixed cars of bulk butter, packed in export containers, grading U. S. Grade B or 90 score and U. S. Grade C or 89 score, if the amount of U. S. Grade C or 89 score butter tendered in each carlot does not exceed 30% of the net weight of the carlot tendered for delivery. Under special provision the DPMA will also accept straight cars of U. S. Grade C or 89 score, packed in commercial containers.

(b) Churnings rejected as below U. S. Grade C should be recorded individually on the grader's memorandum, but should be shown on the certificate only as total number of churnings and total number of packages rejected. In connection with rejected churnings, comments or score should not be shown on the certificate. However, in the event a vendor desires a certificate covering rejections, a separate certificate may be issued, in which case rejections need not be shown on the original certificate with the accepted churnings.

WEIGHING PROCEDURE -

(a) Before making weight test, the scales should be tested for accuracy by the use of test check weights.

(b) Weight tests should be made by weighing one sample from each churning in the lot. In case of packages weighing less than 50 pounds each, weigh two packages at one time. If butter is not marked by churnings the test weight shall be made by weighing 5% of the packages in the lot.

(c) Average tare weights of parchment tub liners and circles, box liners, print wrappers, plus box liners are as follows:

63-pound tub liners and circles	-----	2 ounces when damp and 3 ounces when wet;
68-pound box liners	-----	3 ounces when damp and 4 ounces when wet;
60-one pound print wrappers plus complete box liner	-----	8 ounces when damp and 10 ounces when wet.

The above average tare weights are based on 27 to 30 pound parchment stock. These tare weights should be used unless parchment weight varies appreciably from the weight of stock indicated above.

(d) Test weights, after weight of liners or wrappers has been deducted, shall be recorded in full pounds or in quarter pound fractions thereof. Intermediate fractions shall be recorded as next lower full pound or quarter-pound fraction thereof. Overages or shortages shall be computed on individual churnings and in case overages equal or exceed shortages show marked weight as total net weight of carlot. In no case shall total net weight exceed marked weight.

(e) Total weight of carlot or recapitulation of grades within a carlot should be recorded on the certificate in full pounds and fractions of pounds, if any. In case of test weight shortages, indicate for each grade the marked weight, test shortage, and net weight of the lot in the body of the certificate.

(f) In all instances, the test weight recorded is net butter "after weight of wrappers, (circles) and liners has been deducted". This statement should be shown under REMARKS and indicated by asterisk at the head of TEST WEIGHT column. In the space on the certificate captioned "Marked or Contractor's Weight", the figure shown should be the contractor's net weight of the lot — strike out the word "Marked".

#### TYPE OF CONTAINER -

(a) Indicate type of container and material used in construction - new, reconditioned or used, and if wire strapped - condition, paraffined and kind of liners (parchment or waxed). If any variation, indicate percentages on certificate.

(b) If containers do not meet specifications, state reason; for example, used containers, if wood measurements below requirements give measurements, if less than six cement coated nails to each nailing edge, state number, whether or not all packages strapped for export, and any other information necessary to DPMA for determining exact basis for settlement.

MARKING CONTAINERS - All stencilling required under the terms of the announcement should be on the package at the time of grading with the possible exception of the contract number. This includes vendor's name, address, name of product, marked weight, churn number, and also contract if available. Markings on the container must be legible; pencil markings not acceptable.

Each carlot of butter shall be assigned a USDA or FDA lot number. When the butter is stored in a public warehouse, it will be necessary to stamp only the samples. When the butter is held in a plant or a private warehouse, each individual container in the lot should be stamped with a USDA or FDA lot number, if at all possible. Samples

shall also be stamped with a special stamp bearing the word "sample" and the vendor should be instructed to load the samples in the doorway of the car.

GRADING BUTTER SHOWING ABNORMAL SURFACE CONDITION OR BELOW U. S. GRADE C -

(a) Any lot of butter with one or more churnings showing mold on the surface of the butter or on the packing material shall be classified as "No Grade". The flavor rating of each churning should be shown on the certificate, but no U. S. grade will be given. Under "Remarks", show the following statement: "This lot of butter classified as 'No Grade' because of mold condition noted on surface and packing material on churning or churnings, \_ \_ \_" (give churning numbers and indicate if mold on both surface of butter and packing material).

(b) In case a carlot of bulk butter contains churnings from more than one plant and the churnings are properly identified either by name of creamery or stencil, then mold found on one lot in the carlot will not affect the grade of other lots, but in all cases, lots from different creameries within a carlot shall be listed on the certificate separately. In case mold is found on any churning of print butter where the entire carlot has been printed in one plant, the entire lot shall be classified as "No Grade."

(c) In cases where mold has penetrated the surface of the butter so that it cannot be removed by scraping a thin layer off the outside surface, the butter shall be classified as "No Grade" and no flavor rating or final score shall be given.

(d) Abnormal surface flavor. - The flavors tallowy, rancid, paint, varnish, gasoline, kerosene, fly spray, or any other chemicals shall be classified as "No Grade" even when present only on the surface of the butter. However, if present only on the surface of the butter, the flavor rating should be given, classifying each churning as "No Grade" with proper comment.

USED AND RECONDITIONED PACKAGES -

(a) Used packages are containers that have been used one or more times without reconditioning.

(b) Reconditioned packages are containers that have been used but have been thoroughly cleaned and reconditioned inside and out and all previous marks removed and nail holes filled before subsequent usage.

RECAP OF GRADES, BULK OR PRINTS, CONTAINERS AND STRAPPING - When more than one grade of butter is covered by the certificate, a weight recapitulation should be shown for each grade. If a carlot contains butter of print and bulk, show the churnings and total poundage for each separately. Also if the carlot contains more than one type of container, the total number of packages for each type according to grades must be clearly indicated on the certificate. Also show number strapped or unstrapped containers if any.

BILLING - The vendor will be the applicant and will be billed by the grading office for the grading on a churning or time basis, whichever is the more equitable, plus subsistence and transportation, if any, incurred by the grader.

INSPECTION FEES AND CHARGES - All inspection fees and charges shall be paid by the vendor, who will be reimbursed by the DPMA for the amount of inspection charges, including traveling and per diem expenses of the grader, but not to exceed \$30.00 per 40,000 pound net carlot, applicable to butter delivered. In the event that churnings of butter offered are not acceptable, the cost of inspection shall be prorated on the total number of churnings tendered. The reimbursement to the vendor by DPMA will be the amount applicable to the churnings accepted for delivery.

CERTIFICATES - Certificates should be prepared and mailed to vendors promptly. Prepare original and six copies and distribute as follows: Original and three copies to vendor, one copy to Washington office, one copy to the supervisor of butter grading in your area, and retain one copy for grader's file.